

Work Order ID 65055

Wednesday, January 05, 2011 4:23:56 PM



Page 1

Item ID: DSI 9372-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 1/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-01-05 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9372	Rev A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPDSI9372-011 CHG001

8 ulord 06

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

1.1.1/6 SP (2x)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 ulord 06(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9372-011 <input type="checkbox"/> Location: <u>20</u> <input type="checkbox"/> PPP Rev: <u>C</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/1/6 52 (50)

CK 11/01/06

MF
11-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 65055

Parent Item: DSI 9372-011

Parent Item Name: Wearshoe



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A ☐ New issue 07-04-09 ☐ JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-130

Purchased

No

120

Each

1,171.000

6

12



Insert

Location

Loc Qty

Loc Code

PKG11

592

114407

15

~~114725~~

577

ST281

444

116049

444

ST282

96

110511

10

115911

86

ST381

39

114654

39

AN3C4A

Purchased

No

120

Each

1,333.000

50

100



BOLT

Location

Loc Qty

Loc Code

ST350

1333

~~115300~~

29

~~115936~~

304

116075

1000

AN960C10L

NAS1149C0332
R

Purchased

No

120

Each

25.0000

50

100



Washer

Location

Loc Qty

Loc Code

ST245

25

107534

25

4

11/1/65

12

11/1/65

96

11/1/65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 65055

Parent Item: DSI 9372-011

Parent Item Name: Wearshoe

Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

D3564-11

Manufactured No

120

Each

14.0000



11/1/6 SP

Wearshoe

Location

Loc Qty

Loc Code

FP019

14

62236

14

Manufactured No

120

Each

22.0000



11/1/6 SP

D3564-13

Wearshoe

Location

Loc Qty

Loc Code

FP17

22

59660

1

61828

9

62229

12

Manufactured No

120

Each

17.0000



11/1/6 SP (2)

D3564-5

Wearshoe

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

14

62237

2

63575

12

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 65055

Parent Item: DSI 9372-011

Parent Item Name: Wearshoe



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

D3564-9

Manufactured No

120

Each

23.0000



Wearshoe



11/1/10 SP

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

7

61709

7

FP19

15

62238

15

D3566-1

Manufactured No

120

Each

18.0000



Gasket



11/1/10 SP

Location

Loc Qty

Loc Code

FP015

18

57715

2

61992

1

62892

3

63573

12

D3566-13

Manufactured No

120

Each

32.0000



Gasket



11/1/10 SP 2X

Location

Loc Qty

Loc Code

FP012

12

61996

12

FP014

20

64070

20

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 65055

Parent Item: DSI 9372-011

Parent Item Name: Wearshoe



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

D3566-5

Manufactured No

120

Each

19.0000



2
11/11/65P



Gasket

Location

Loc Qty

Loc Code

FP	12	
64789	12	
FP015	7	
63574	7	

2

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9372	REV. A SHEET 1 OF 2
DATE 07.03.19		TITLE STAINLESS STEEL WEARSHOE KITS	SCALE NTS
A	07.03.19	NEW ISSUE	

REFERENCE ONLY

DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. D OR EARLIER AND
INSTALLATION INSTRUCTIONS D204-635 REV. D OR EARLIER**

REF. CANADIAN STC: SH96-88 ISSUE 3

REF. FAA STC: SR00563NY

For customers with D205-634-011 skidtubes at CHG 004 or earlier and D205-634-015 skidtubes at CHG 003 or earlier who would like to upgrade to stainless steel wearshoes, the DSI 9372-011 wearshoe kit can be obtained from Dart

or

For customers with D204-635-011 skidtubes at CHG 004 or earlier who would like to upgrade to stainless steel wearshoes, the DSI 9372-013 wearshoe kit can be obtained from Dart

QTY -011	QTY -013	Part Number	Description
X		DSI 9372-011	WEARSHOE KIT (D205-634-011/-015 SKIDTUBES)
	X	DSI 9372-013	WEARSHOE KIT (D204-635-011 SKIDTUBES)
1		D3564-5	WEARSHOE (REPLACES D2577-5)
	1	D3564-7	WEARSHOE (REPLACES D2577-7)
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-13	*WEARSHOE
2	2	D3566-1	GASKET
1		D3566-5	GASKET
	1	D3566-7	GASKET
1	1	D3566-13	*GASKET
50	44	AN3C4A	BOLT
50	44	AN960C10L	WASHER
6	6	ALS4-1032-130	*INSERT

* OPTIONAL TO INSTALL

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

[Signature]
D. SHEPHERD (DE # 02)

DATE: 07.03.19

CERT. NO.: SH96-88

ISSUE NO.: 3

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DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9372	REV. A SHEET 2 OF 2
DATE 07.03.19		TITLE STAINLESS STEEL WEARSHOE KITS	SCALE NTS

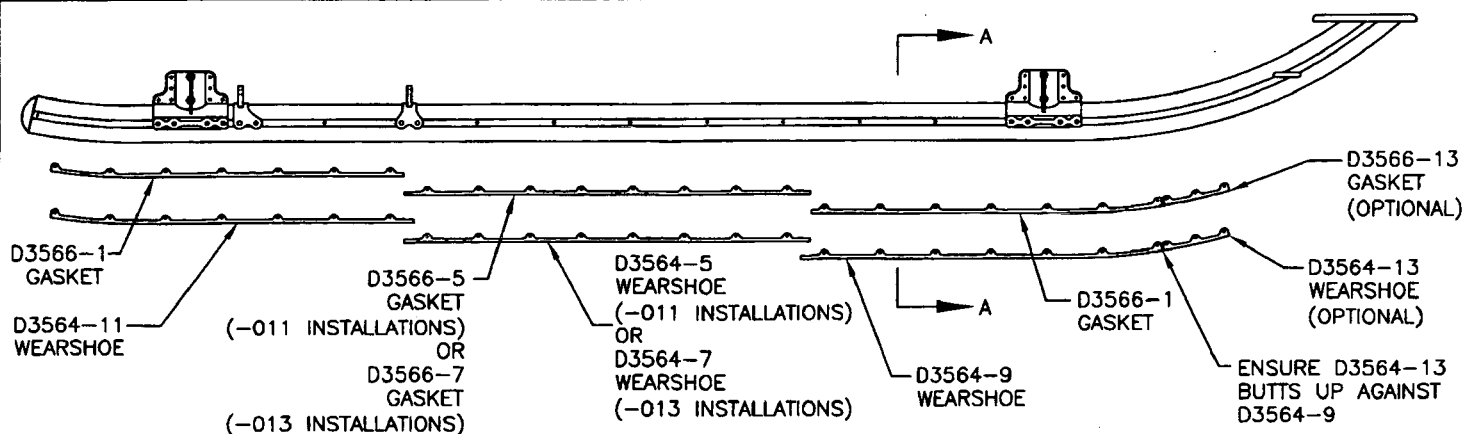
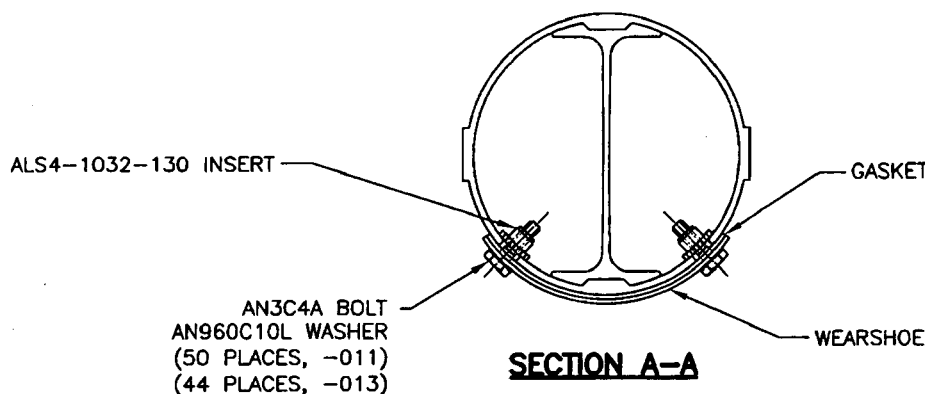


FIGURE 1: DSI9372-011/-013 WEARSHOE KIT INSTALLATION
(D205-634-011 SKIDTUBE SHOWN, D204-635-011 SIMILIAR)



REFERENCE ONLY
5

DSI 9372-011/-013 Wearshoe Kit Installation Procedure

- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D205-634 or ICA-D204-635.
- 2) Remove existing D2577-1/-3/-5/-7 wearshoes by removing AN3 hardware. Begin wearshoe removal from the fwd end of the skidtube towards the aft end.
Note: Removing the wearshoes may require breaking a layer of sealant between the wearplates and the skidtube.
- 3) Clean residual sealant off the bottom of the skidtube. Check for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D205-634 or ICA-D204-635 and repair as required.
- 4) **Installation of D3564-13 Wearshoe and D3566-13 Gasket (optional)**
Temporarily install the D3564-9 wearshoe complete with D3566-1 gasket at the fwd end of the skidtube as shown in Figure 1. Temporarily clamp the D3564-13 wearshoe and D3566-13 gasket ensuring that the wearshoe butts up against the D3564-9 wearshoe. Using the D3564-13 wearshoe as a template, drill $\varnothing 0.125$ holes in the center of the wearshoe obrounds (6 places). Remove wearshoes and open the $\varnothing 0.125$ holes to $\varnothing 0.297$. Deburr. Touch up holes with chemical film material (Alodine 1200/1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer. Install ALS4-1032-130 inserts.
- 5) Install D3564-5/-7/-9/-11/-13 wearshoes complete with D3566-1/-5/-7/-13 gaskets using AN3C bolts beginning from the aft end of the skidtube and install towards the fwd end of the skidtube as shown in Figure 1. Seal all bolts with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts to 15-25 in-lbs (1.7-2.8 N-m).
- 6) Re-install skidtube on aircraft per Section 32.2 of ICA-D205-634 or ICA-D204-635.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.03.19
CERT. NO.: SH96-88
ISSUE NO.: 3

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